

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012933**Date Inspected:** 29-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (1AAE-1AE)

This QA inspector checked excavated areas of weld joint -001 located on PCMK OBE1 Deck Panel of 1AAE-1AE.

Excavation was been performed against UT report attached along with Critical Welding Repair Report B-CWR868 Rev.0. The area excavated by ZPMC appeared to comply with the UT report.

OBG # TRIAL ASSEMBLY YARD (1AAE-1AE)

This QA inspector witnessed Magnetic particle Testing (MT) prior to welding of excavated locations of weld joint -001 located on PCMK OBE1 Deck panel of 1AAE-1AE. Y locations of excavated areas was checked and appeared to comply with the UT report attached along with Critical welding report B-CWR868 Rev.0.

OBG # TRIAL ASSEMBLY YARD (1AE-1BE)

SMAW Process:

Welding of weld joint -008 located on PCMK OBE1A Bottom panel of 1AE-1BE. Welder is identified as 045196. ZPMC CWI is identified as Wuzhi Cheng. Welding was been performed against Critical Welding Repair Report B-CWR874 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G

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(4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (1AW-1BW)

SMAW Process:

Welding of weld joint -007 located on PCMK OBE1A Side panel of 1AW-1BW. Welder is identified as 054467. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

SMAW Process:

Welding of weld joint -006 located on PCMK OBE1A Side panel of 1AW-1BW. Welder is identified as 054467. ZPMC CWI is identified as Xu Yumin. Welding was been performed against Critical Welding Repair Report B-CWR875 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (1AE-1AAE)

SMAW Process:

Welding of weld joint -001 located on PCMK OBE1 Deck panel of 1AE-1AAE. Welder is identified as 045196. ZPMC CWI is identified as Wuzhi Cheng. Welding was been performed against Critical Welding Repair Report B-CWR868 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer